

# Work Order ID 91845

October-19-12 12:45:08 PM

\*91845\*

~~DWG~~ ~~U/R~~

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Item ID: D3256-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Panel  
 Start Date: 10/18/12 Start Qty: 6.00 \*6\* Cust Item ID:  
 Required Date: 11/02/12 Req'd Qty: 6.00 \*6\* Customer:  
 Reference:

Approvals: Process Plan: [Signature] Date: 12-10-12 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3256	D								
100	FLOW WATER JET	0.00							
*100*									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3256								
384-032	Dwg Rev: <u>D</u>								
	Prog Rev: <u>D</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
*110*									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
*120*									
QC	Memo	0.00							
Quality Control									

6 1312-10-21

6 1312-10-21

Smb  
12/10/22

6



**Work Order ID 91845****\*91845\***

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Item ID: D3256-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Panel

Start Date: 10/18/12 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 11/02/12 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

12/11/22 *[Signature]*  
MLF  
12-11-21

# Picklist Print

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Page 1

Work Order ID: 91845

Parent Item: D3256-1

Parent Item Name: Panel

Start Date: 10/18/12

Required Date: 11/02/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-09-28 EC verified by:DD  
IPP Rev:b ECN 1052 07-10-31 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA		Purchased	No			100	sf	219.1800	0.987	6.2336844			

304/316 .032 Sheet

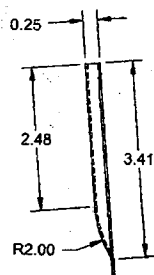
1812-10-21

Location	Loc Qty	Loc Code
MAT020	219.18	
118271	8.88	
120866	32.8	
121889	152.75	
122736	24.75	

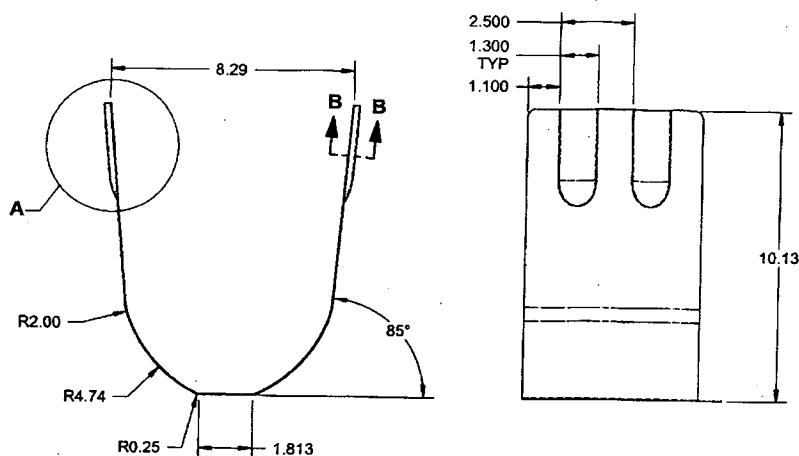
121889

(6)

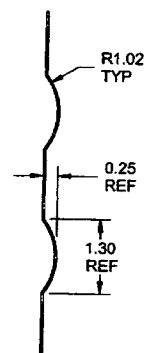




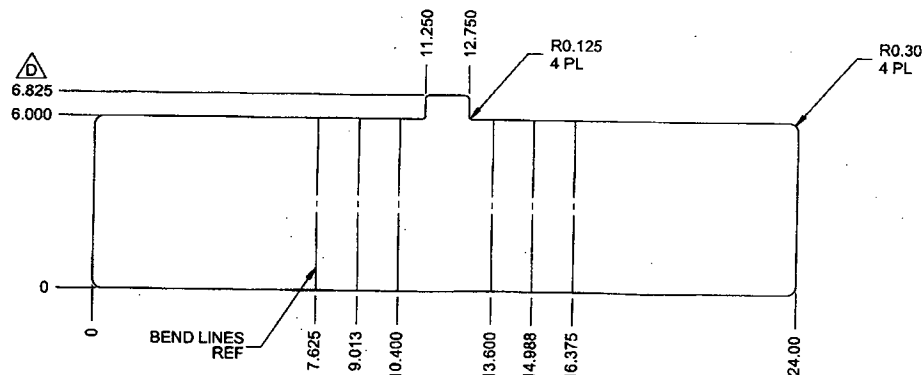
**DETAIL A**  
SCALE 2X



**D3256-1 ACCESS PANEL**  
(MAKE FROM D3256-1F)



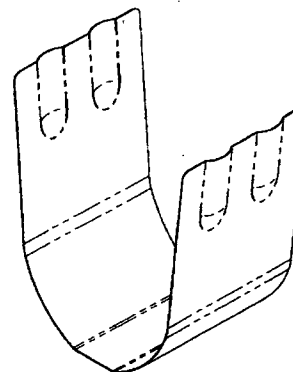
**SECTION B-B**  
SCALE 2X  
(VIEW ROTATED)



**D3256-1F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 0.032 THICK  
PER MIL-S-5019 OR AMS 5513/AMS 5524 OR ASTM A240 OR ASME SA240  
REF. DART SPEC. M304S22GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3256-1" AND B/N "BXXXX" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 1.37 lbs



97845

**RELEASE**  
2011-11-10  
**UNDER REVIEW**  
12.10.10  
FOR CAE264 -10K!

D	UPDATED TO COMPLY WITH QSI 043; REMOVED "FORM JOGGLE PER D3256-1T1" AND "FORM PER D3256-1T2" (SEE PREVIOUS REV FOR REFERENCE); 6.825 WAS 6.450 (ZN B7-1); 0.83 WAS 0.45 (ZN C8-2); REASON: PAR11-124.	MB	11.10.25
C	D3256-041 ELIMINATED; REMOVED (QTY 22) 0.128 HOLES FROM D3256-1F AND D3256-3 GASKET. INSTRUCTIONS TO DRILL HOLES AND INSTALL D3256-3 GASKET ARE NOW PART OF THE INSTALLATION INSTRUCTIONS	MB	07.09.28
B	D3256-3 DIM 1.30 WAS 0.65	RF	05.06.27
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.25		

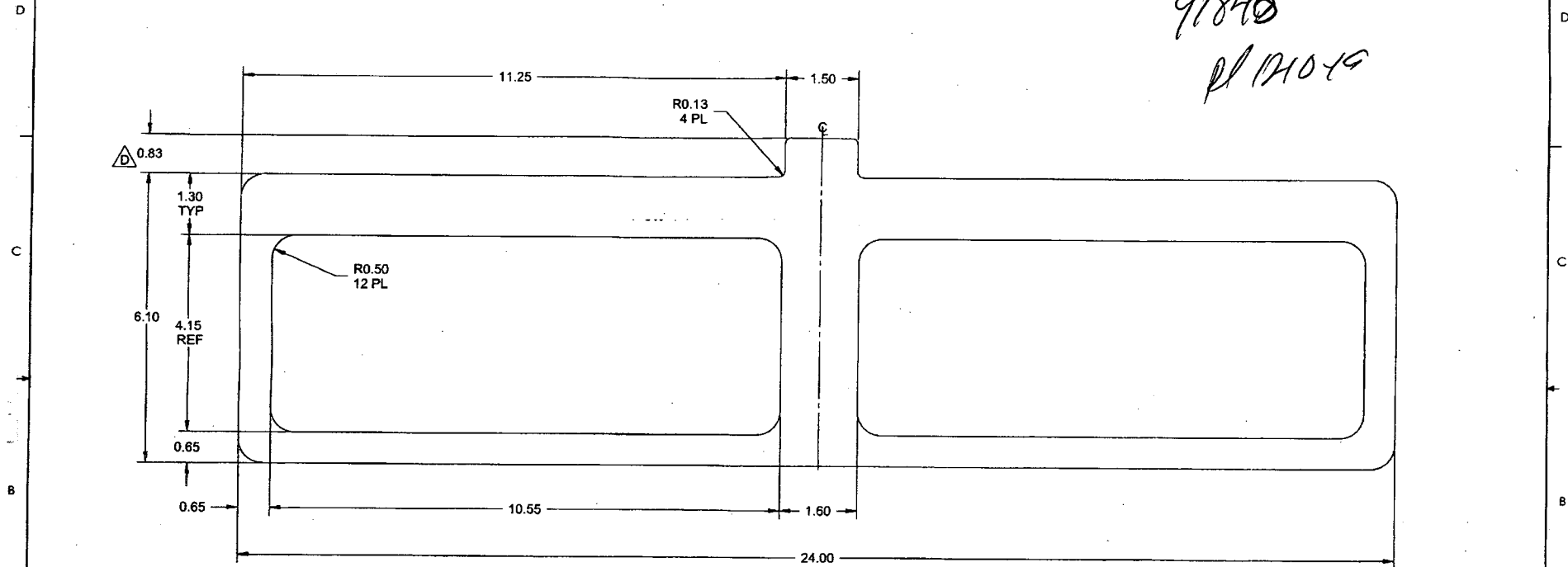
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3256** REV. D  
SHEET 1 OF 2

TITLE **ACCESS PANEL** SCALE NTS

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91845  
R/121049

**D3256-3 GASKET**

RELEASE  
2011-11-10  
UNDER REVIEW  
12.10.10

- NOTES:
- 1) MATERIAL: DURABLE BLACK GASKET 0.035 THICK  
PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A OR AMS 3232  
REF. DART SPEC. MDURAS.035
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.08 lbs

DESIGN	#	<b>DART AEROSPACE LTD</b>	
DRAWN	#	HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	DRAWING NO.	REV. D
MFG. APPR.	#	D3256	SHEET 2 OF 2
APPROVED	#	TITLE	SCALE
DE APPR.	#	ACCESS PANEL	UNITS
DATE	11.10.25	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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